

Work Order ID 71979

Thursday, July 14, 2011 3:19:20 PM



Page 1

Item ID:	D4035-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Aft (350 Basket)					
Start Date:	7/14/2011	Start Qty:	3.00	Cust Item ID:		
Required Date:	7/22/2011	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: M11578 0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAD 11-07-25

11.07.26 (3)

110 QC10- Inspect visual per QSI004- ground welds 0.00



QC

Quality Control

Memo

0.00

3 0 BE 11/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71979

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Page 2

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 26 (3)

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11.07.26 (3)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/07/26 (3)

11-07-26 (3)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, July 14, 2011 3:19:27 PM

Page 1

Work Order ID: 71979

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA: new-issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9		Manufactured	No			100	Each	94.0000	2	6			
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Bushing

Location	Loc Qty	Loc Code
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WA	92	
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68003	28	
-------	----	--

40333	64	
-------	----	--

WA005	2	
-------	---	--

66437	2	
-------	---	--

M304TS0.750W.049	Purchased	No				100	f	453.7147	1.75	3.684211			
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304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
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MAT018	138.534289	
--------	------------	--

117690	34.581189	
--------	-----------	--

11775	103.9531	
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MAT034	15.1804	
--------	---------	--

117337	15.1804	
--------	---------	--

WA	300	
----	-----	--

118184	300	
--------	-----	--

11.07.26

4
2

SAD 11-07-25

5.5265

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

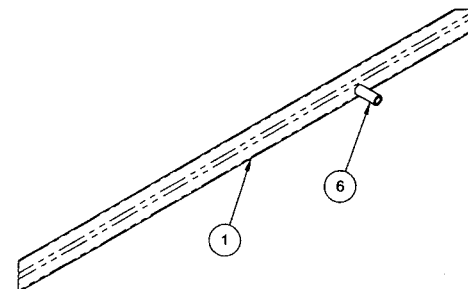
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

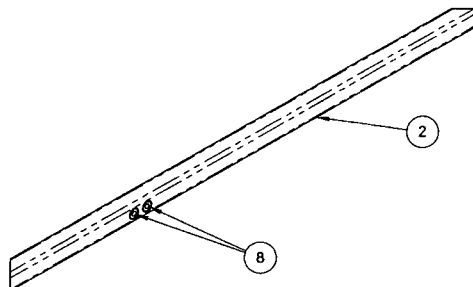
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NOTE: Date & initial all entries

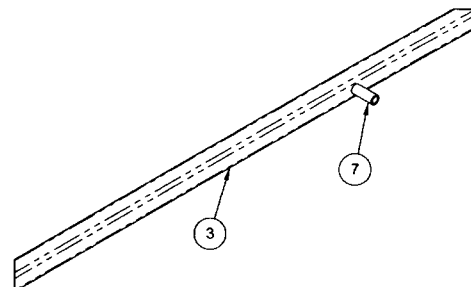
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



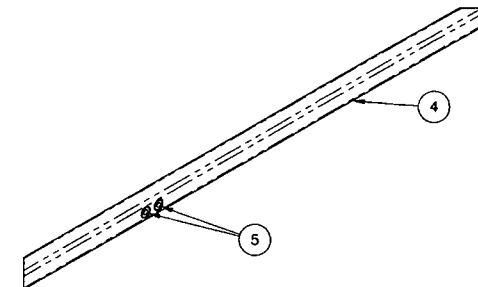
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71979-11-07-14

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4035** REV. A
SHEET 1 OF 5
TITLE **BASKET LID RIB ASSY** SCALE NTS

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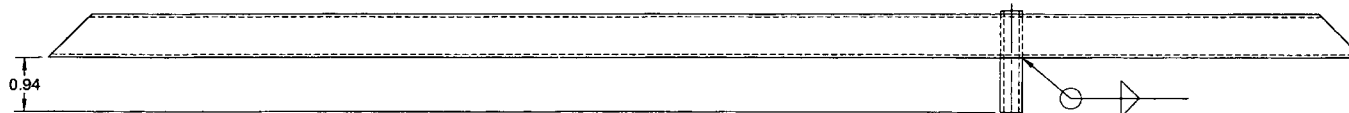
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD

C

C



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

11979

D4035-043 BASKET LID RIB ASSY, AFT




B

B

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

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8 7 6 5 4 3 2 1

D

D

D4035-5
RIB

D2953-175
SPACER

0.94

C

C

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

B

B

D4035-11
BUSHING
2 PL

G
G
TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
NW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

11979

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MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

A

A

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8

7

6

5

4

3

2

1

D

D

C

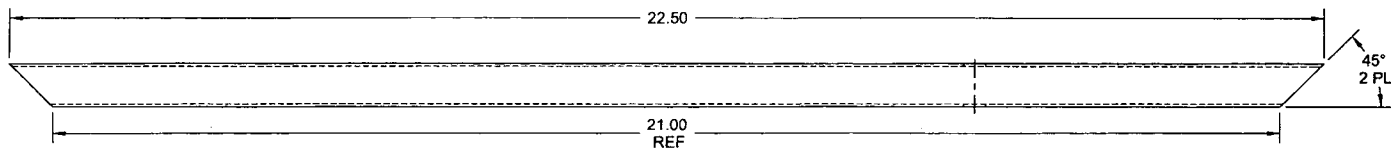
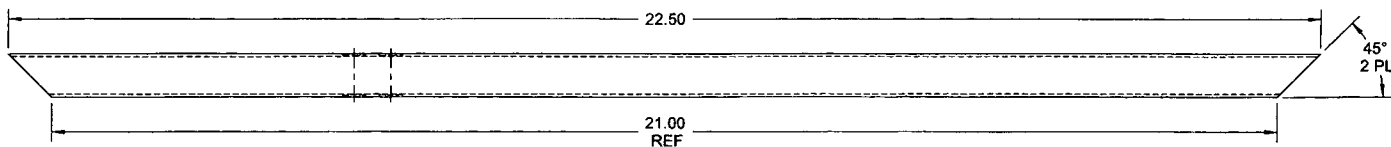
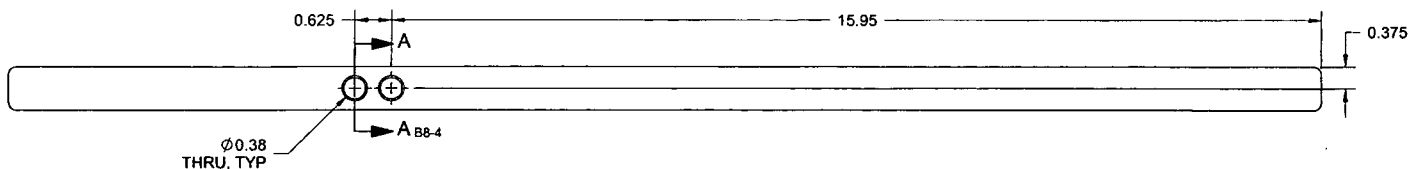
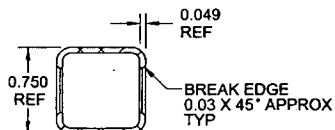
C

B

B

A

A

**D4035-1 RIB****D4035-3 RIB****SECTION A-A** B5-4**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

11979

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2010-03-12
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4035	SHEET 4 OF 5
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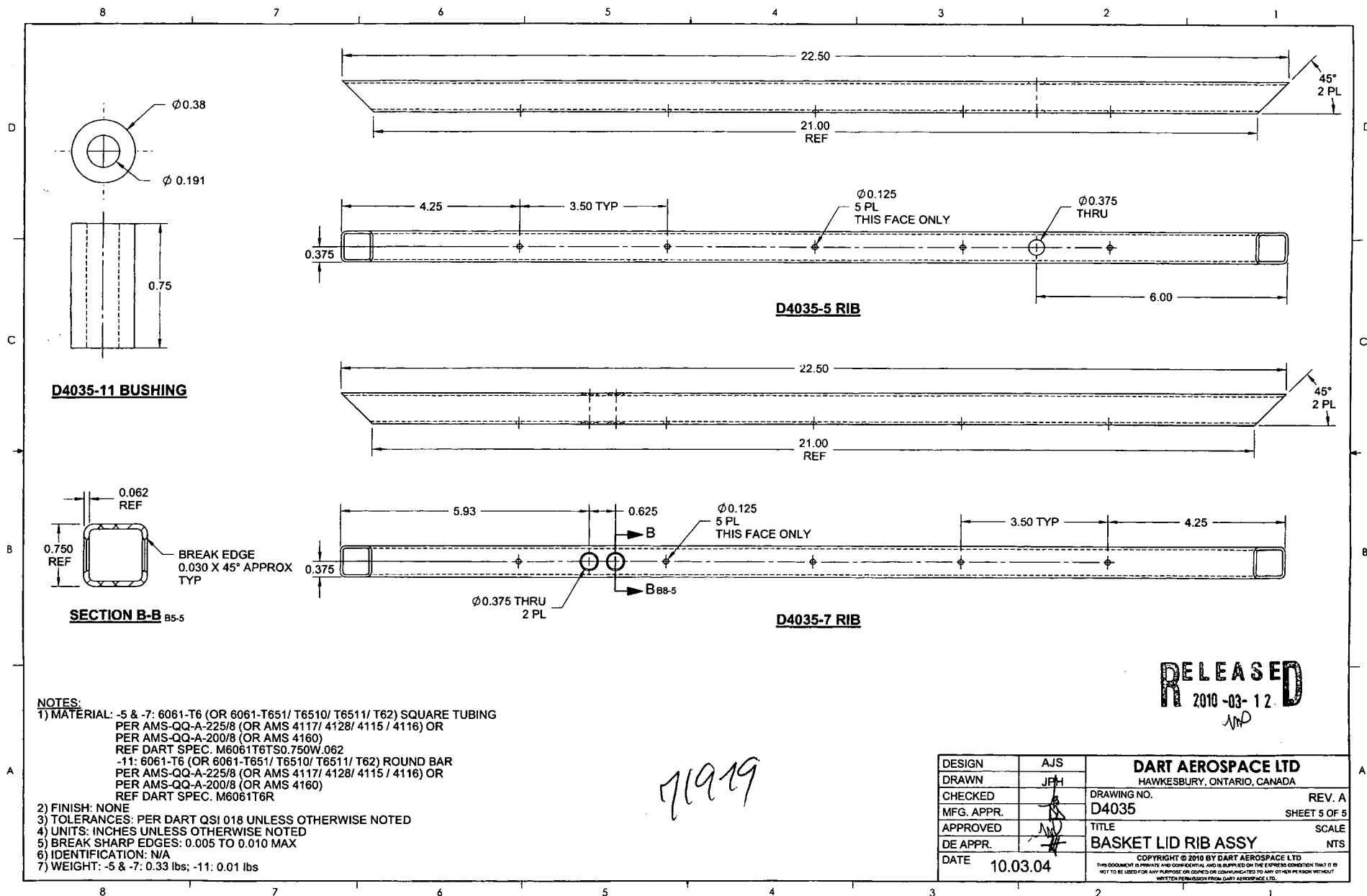
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